



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3294-1

Job Sheet 212811



Part No: D3294-1

Job Qty: 8 pcs

Part Name: Bracket For Interior Window For -115



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/4/20

Job Tracking No:

Due Date: 9/17/20

Created By: Dana Andrews

Type: SOLD

Description:

Note: DWG REV D IPP A 04.08.24 New issue KJ/JLM IPP Rev:B Now On Waterjet 07-03-26 JLM IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs			0.17	2.56	Waterjet - Flow		20/09/09
110	QC 2	8 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/09/09
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 2 - 83	
			QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
120 QC 8	8 pcs	0.00 0.00	QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
130 Small Fab - Brake NC - B4B	8 pcs	0.25 1.10	Small Fab - Brake - 1 - B4B	
			Small Fab - Brake - 2 - B4B	
			Small Fab - Brake - 3 - B4B	
140 QC 5	8 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	

SEP 15 2020
DAS 40
0-88

SEP 15 2020

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170 Small Fab - 2 - B4B	8 pcs	0.00 1.25	QC 7 - 82	
			QC 7 - 87	
			Small Fab - 1 - B4B	DAS
			Small Fab - 2 - B4B	58 SEP 21 2020
			Small Fab - 3 - B4B	9-89
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
180 QC 5	8 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	DAS SEP 21 2020 40
			QC 5 - 61	9-89
			QC 5 - 81	
			QC 5 - 82	
190 Powdercoat - 4 Black Sand - B4B M156440- START: 10:40. O.V.T: 320° FINISH: 11:10.	8 pcs	0.00 0.35	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	20-09-21 34 9-89
			Powdercoat - 4 - B4B	
			Powdercoat - 5 - B4B	
			Powdercoat - 6 - B4B	
			Powdercoat - 7 - B4B	
			Powdercoat - 8 - B4B	
			Powdercoat - 9 - B4B	
			Powdercoat - 10 - B4B	
200 QC 3	8 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	

			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	DAS
			QC 3 - 61	82
			QC 3 - 81	9-89
			QC 3 - 82	SEP 21 2020
			QC 3 - 87	
			QC 3 - 47	
210 Packaging 3-1 - Stock - B4B	8 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	DAS
			Packaging 3 - 5 - B4B	28
			Packaging 3 - 6 - B4B	7-89
			Packaging 3 - 7 - B4B	SEP 21 2020
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
220 QC 21 - SA	8 pcs	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	28
			QC 21 - SA - 9	8-89
			QC 21 - SA - 77	SEP 21 2020
			QC 21 - SA - 28	

Part Op 100 - 1-Cut as per Dwg D3294 CUT File D3294-3 Dwg Rev: D Prog Rev: D *grain direction on a 45 deg as
 Descriptions: per dwg** 2-Deburr if necessary

- 110 - (QC2- Inspect parts off machine FAI/FAIB)
- 120 - (QC8- Inspect parts - second check)
- 130 - 1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)
- 140 - (QC5- Inspect part completeness to step on W/O)
- 150 - (Chemical Conversion Coat per QSI005 4.1)
- 160 - (QC7-Inspect Chemical Conversion Coat)

170 - 1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

180 - QC5- Inspect part completeness to step on W/O)

190 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) Start Time:_____ Oven Temperature:_____ Finish Time:_____

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location:_____)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	14.4000 sf (1.8 ea)	100-Waterjet - Flow - 1	S2646407
D3294-5	Doubler 129	8 pcs (1 ea)	170-Small Fab - 2 - B4B	S263390
MS20470AD4-5	Rivet, Universal Head 1209	120 Ea (15 ea)	170-Small Fab - 2 - B4B	S2S1283

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	14	144	0
170-Small Fab - 2 - B4B	D3294-5	8	6	0
	MS20470AD4-5	120	1,006	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 212811
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

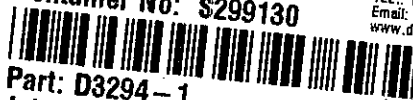
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø.128	1		V.D.C.	
Ø0.141	+0.005/-0.001	Ø.140	1		" "	
6.708	+/-0.010	6.707	1		" "	
1.118	+/-0.010	1.117	1		" "	
5.590	+/-0.010	5.591	1		" "	
1.118	+/-0.010	1.117	1		" "	
13.563	+/-0.010	13.563	1		" "	
1.043	+/-0.010	1.044	1		" "	
0.625	+/-0.010	.624	1		" "	
0.325	+/-0.010	.326	1		" "	
0.300	+/-0.010	.302	1		" "	
0.400	+/-0.010	.401	1		" "	
6.000	+/-0.010	5.999	1		" "	
1.000	+/-0.010	1.001	1		" "	
17.124	+/-0.010	17.124	1		Tape	
16.13	+/-0.030	16.13	1		"	
7.27	+/-0.030	7.27	1		"	
11.97	+/-0.030	11.97	1		"	
8.37	+/-0.030	8.37	1		"	
20.05	+/-0.030	20.05	1		"	
12.98	+/-0.030	12.98	1		"	
14.59	+/-0.030	14.59	1		"	
11.66	+/-0.030	11.66	1		"	
0.080	+/-0.010	.080	1		V.D.C.	

Measured by: <i>DC</i>	Audited by: <i>DAS 40</i>	Preliminary Approval:
Date: 20/09/09	Date: SEP 19 2020	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	<i>MA</i>

DART
AEROSPACE

Container No: S299130



Part: D3294-1

Job No: 212811

Serial No/Batch: S299130

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

CANADA

TEL: 1 813 632-6200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 09/09/20